Work Order ID 120817

Wednesday, June 11, 2014 10:33:26 AM

120817

Item ID: D4635-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Fwd Ceiling Panel, LH **Stop** *NS2*

Start Date: 7/02/14 **Start Qty:** 1.00 *1*

Required Date: 7/02/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** 14/6/11 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4635 / E									
100		0.00							68-6 07 DAS
100	HAND FINISHING THERMOFORMING					x1			
Thermoform	**Memo**	0.00							
Thermoforming Machine	Cut Blanks								14/07/17
105		0.00							
105	Dry Material								
HandThermo	**Memo**	0.00							14/07/17
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: 245 °

Time IN: 4:30

Time OUT: 7:00

JUL 17 2014

Per.....

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

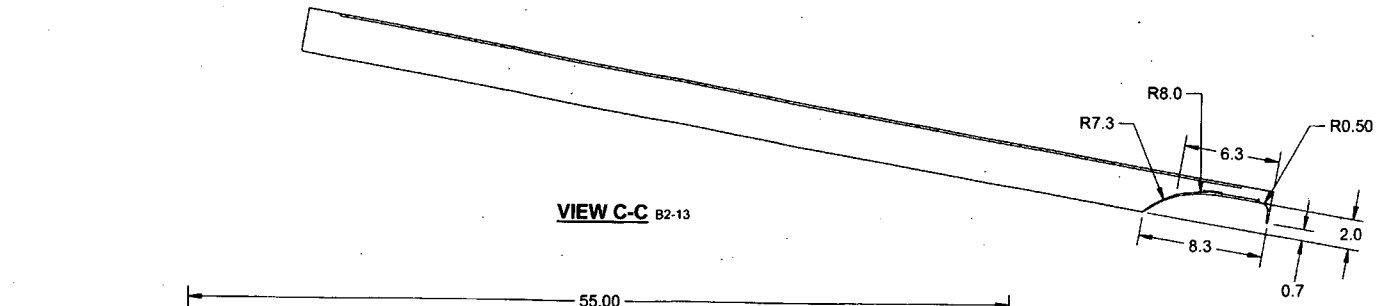
☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

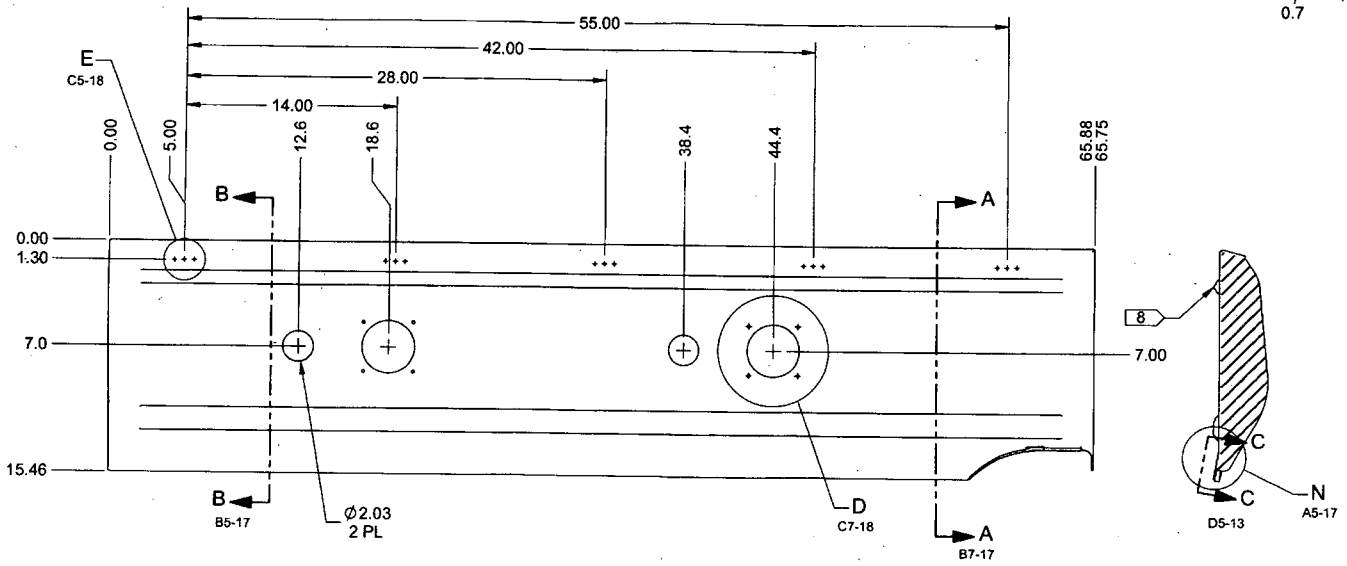
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other



VIEW C-C B2-13



NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.39 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-1 PER TOOL DT9839
10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

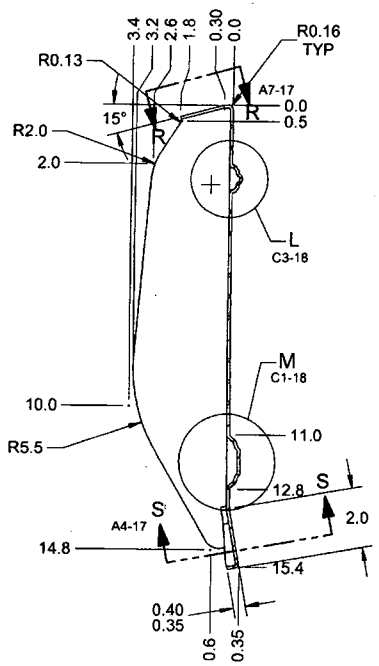
D4635-1 LH, FWD CEILING PANEL

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120817MP
14-6-11

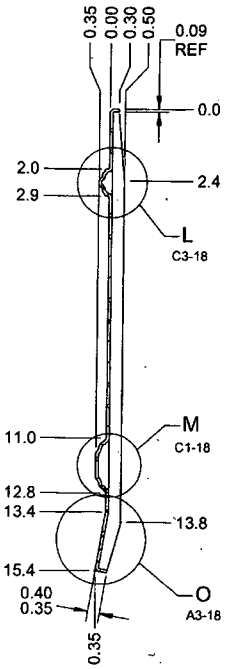
RELEASED
2014-01-22

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4635 REV. E
MFG. APPR.		SHEET 13 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE 14.01.09		

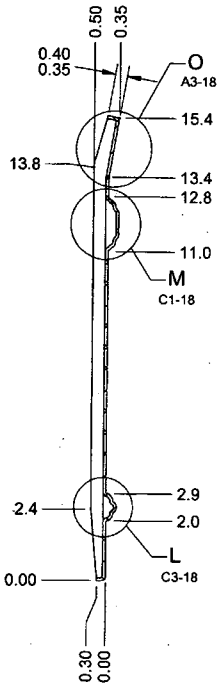
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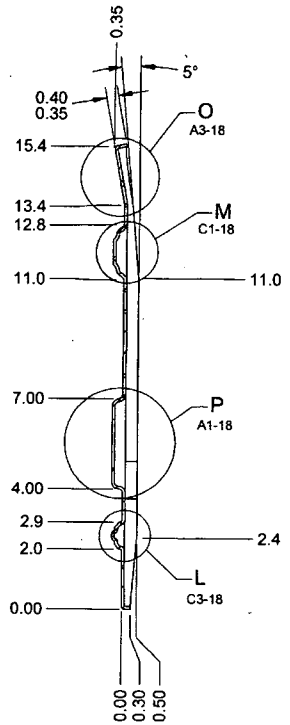
SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



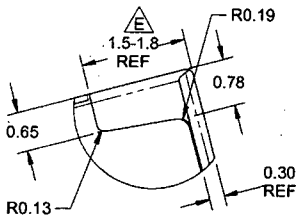
SECTION B-B B7-13 B7-14
SCALE 2X



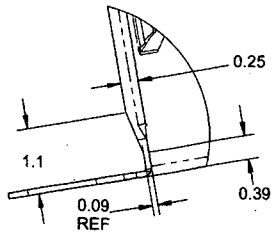
SECTION G-G B4-15 B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R D7-17
SECTION R'-R' OPPOSITE
SCALE 2X

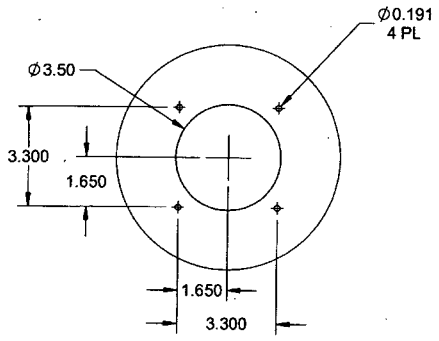


AUXILIARY VIEW S-S B7-17
SECTION S'-S' OPPOSITE
SCALE 2X

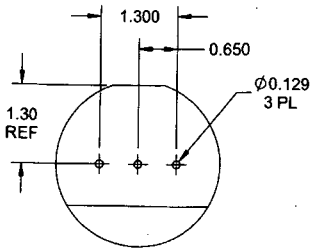
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DATE 14.01.09			

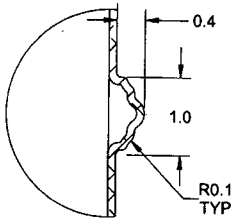
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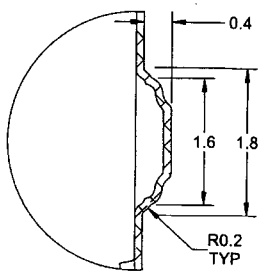
DETAIL D B4-13 B3-14 B5-15 B5-16
SCALE 2X



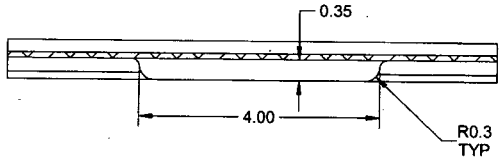
DETAIL E C7-13 B6-14 C6-15 B5-16
SCALE 4X



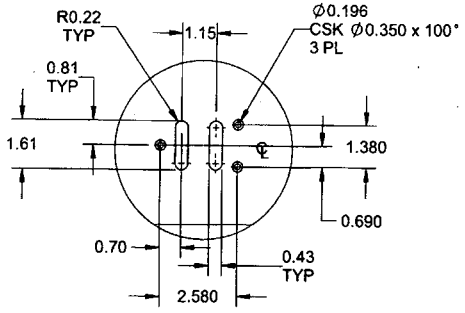
DETAIL L B2-17 B4-17 C5-17 C7-17
SCALE 1.5X



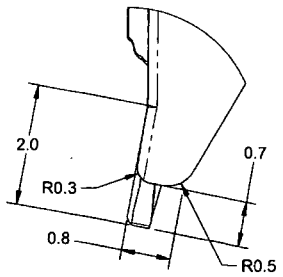
DETAIL M C2-17 C3-17 C5-17 C7-17
SCALE 1.5X



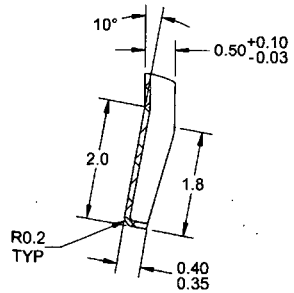
SECTION I-I B5-16
SCALE 4X



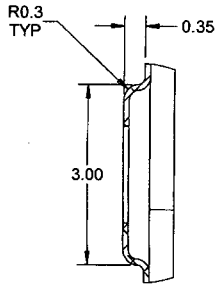
DETAIL Q C5-16
SCALE 2X



DETAIL N B2-13
SCALE 2X



DETAIL O D2-17 D3-17 B5-17
SCALE 2X



DETAIL P C2-17
SCALE 4X

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APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
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DART AEROSPACE LTD

Description: Fwd Ceiling Panel		Work Order:	B120817
Inspection Drawing: 4635-1	Rev: E	Part Number:	D4635-1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.00	+/- 0.030	14.00	✓		S. Feb-21	
28.00	+/- 0.030	28.00	✓		"	
42.00	+/- 0.030	42.00	✓		"	
55.00	+/- 0.030	55.00	✓		"	
5.00	+/- 0.030	.502	✓		"	
12.6	+/- 0.100	12.6	✓		"	
18.6	+/- 0.100	18.6	✓		"	
38.4	+/- 0.100	38.4	✓		"	
44.4	+/- 0.100	44.4	✓		"	
1.3	+/- 0.100	1.365	✓		S. Feb-08	
7.0	+/- 0.100	7.00	✓		"	
7.00	+/- 0.030	7.00	✓		"	
Ø 2.03	+0.002 -0.001	2.028	✓		"	
Ø 0.791	+0.005 -0.001	.792	✓		"	
Ø 3.50	+/- 0.010	3.50	✓		"	
3.300	+/- 0.010	3.306	✓		"	
1.650	+/- 0.010	1.649	✓		"	
Ø 1.29	+0.005 -0.001	1.28	✓		"	
1.300	+/- 0.010	1.304	✓		"	
0.650	+/- 0.010	0.655	✓		"	
.35 - .40	+/- 0.030	0.386	✓		"	
.30	+/- 0.030	.314	✓		"	
.50	+/- 0.30	.527	✓		"	

Measured by: DAS 27 9-89	Checked By: DAS 9 9-89	QC inspector:	Engineering Approval (*if necessary*):
Date 14/7/29	Date 14-07-25	Date 14-07-29 DAS 9 9-89	Date